

CLAIMS :

1. A method for producing a cylindrical hollow body from a blank, with the workpiece being opened in the core region by successive swaging which is angularly offset against each other about the axis of the workpiece and being simultaneously pushed onto a piercing mandrel, characterized in that the workpiece is pressed during the swaging with a predeterminable axial force against the piercing mandrel which can be advanced against the workpiece against this axial force, which piercing mandrel is moved back to its initial position synchronous with the axial feed of the workpiece between successive swaging steps.
2. A method according to claim 1, characterized in that prior to swaging the workpiece is provided with a centric depression on its face side facing the piercing mandrel.
3. A method according to claim 1 or 2, characterized in that the piercing diameter of the workpiece is increased each in successive steps in a graduated manner under swaging.
4. An apparatus for performing the method for producing a cylindrical hollow body according to one of the claims 1 to 3, comprising at least two forging tools which are situated diametrically opposite of each other with respect to the workpiece, a chuck upstream of the forging tools in the direction of feed of the workpiece, which chuck is connected with an axial feed drive and a rotary drive, and a piercing mandrel which is axially displaceable by means of an actuator on the side of the forging tools opposite of the upstream chuck, characterized in that the chuck (4) upstream of the forging tools (1) is provided with a face-side stop (10) for the workpiece (2) as well as a pressing cylinder (12) for the workpiece (2) supported on the face side, and that the piercing mandrel (20) is displaceable axially in a reciprocating fashion via its actuator (21) depending on the feed drive (8) of the chuck (4).

5. An apparatus according to claim 4, characterized in that the pressing cylinder (12) is associated with the chuck (4) and pressurizes the face-side stop (10) for the workpiece (2), which stop forms a receiving opening (26) for the piercing mandrel (20).
6. An apparatus according to claim 4 or 5, characterized in that the pressing cylinder (12) is connected with a rotary drive (13) for the face-side stop (10).
7. An apparatus according to one of the claims 4 to 6, characterized in that the piercing mandrel (20) comprises a piercing tool (22) with graduated diameter sections (27, 28).
8. An apparatus according to one of the claims 4 to 7, comprising a chuck which is downstream of the forging tools, is connected with a feed drive for the workpiece and is penetrated by the piercing mandrel, characterized in that both chucks (4, 14) are equipped with a pressing cylinder (12) for pressurizing the workpiece (2) on the face side and the piercing mandrel (20) penetrates the pressing cylinder (12) of the associated chuck (4, 14).
9. An apparatus according to claim 8, characterized in that the two chucks (4, 14) are associated with a piercing mandrel (20) penetrating the associated pressing cylinder (12).